

ABSTRACT OF THE DISCLOSURE

A feed rate of a single-point cutting tool, which is an axial relative moving distance of the cutting tool along an outer peripheral surface of an unfinished commutator product per revolution of the unfinished commutator product, is reduced in an end part of a cutting region of the outer peripheral surface of the unfinished commutator product, which is adjacent to a commutator riser of each commutator segment provided in the outer peripheral surface of the unfinished commutator product.